

Work Order ID 66882

Wednesday, March 02, 2011 8:06:06 AM



Page 1

Item ID:	DSK076	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	D2891-1 TURNING DETAIL					
Start Date:	3/2/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	3/7/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11/03-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
DSK076	Rev A								

100	DOOSAN LATHE	0.00				10	φ		
Doosan	Memo	0.00							
Doosan Lathe	Turn blank for as per Folio FA046			11/5/12					

110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	φ		
QC	Memo	0.00							
Quality Control				11/5/12					

120	QC8- Inspect parts - second check	0.00				10			
QC	Memo	0.00							
Quality Control				11/05/12					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66882

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Page 2

Item ID: DSK076

Accept



Setup Start



Revision ID:

Stop



Item Name: D2891-1 TURNING DETAIL

Start Date: 3/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: MAT60

JK 11/05/05

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/5/05

MF
11-05-05

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 02, 2011 8:06:13 AM

Page 1

Work Order ID: 66882

Parent Item: DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 3/2/2011

Required Date: 3/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003

Manufactured No

Each

9.0000

10



Round Billet, 17-4

SA 11/5/12

Location

Loc Qty

Loc Code

MAT43

9

53750

3

60943

6

66960

110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66882
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.279	2.279	2.279	2.279	2.279
B	3.702	3.722		3.719	3.715	3.714	3.714	3.714
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.037	2.037	2.038	2.037	2.037
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.927	.925	.926	.926	.926
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.101	.101	.101	.101	.101
L								
M								
N								
O								
P								

Measured by: SA **Date:** 11/5/2

Audited by: JL **Date:** 11/05/05

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66882
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
Lathe Section								
A	2.274	2.279		2.278	2.279	2.278	2.278	2.278
B	3.702	3.722		3.714	3.714	3.714	3.714	3.714
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.464	2.484		2.472	2.472	2.473	2.473	2.473
G	2.029	2.049		2.037	2.037	2.037	2.037	2.037
H	2.964	2.984		2.974	2.974	2.974	2.975	2.975
I	0.913	0.933		.926	.926	.926	.926	.926
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.098	.098	.098	.098	.098
L								
M								
N								
O								
P								

Measured by: SL **Date:** 11/5/13

Audited by: SL **Date:** 11/8/13

Prototype Approval: **Date:**

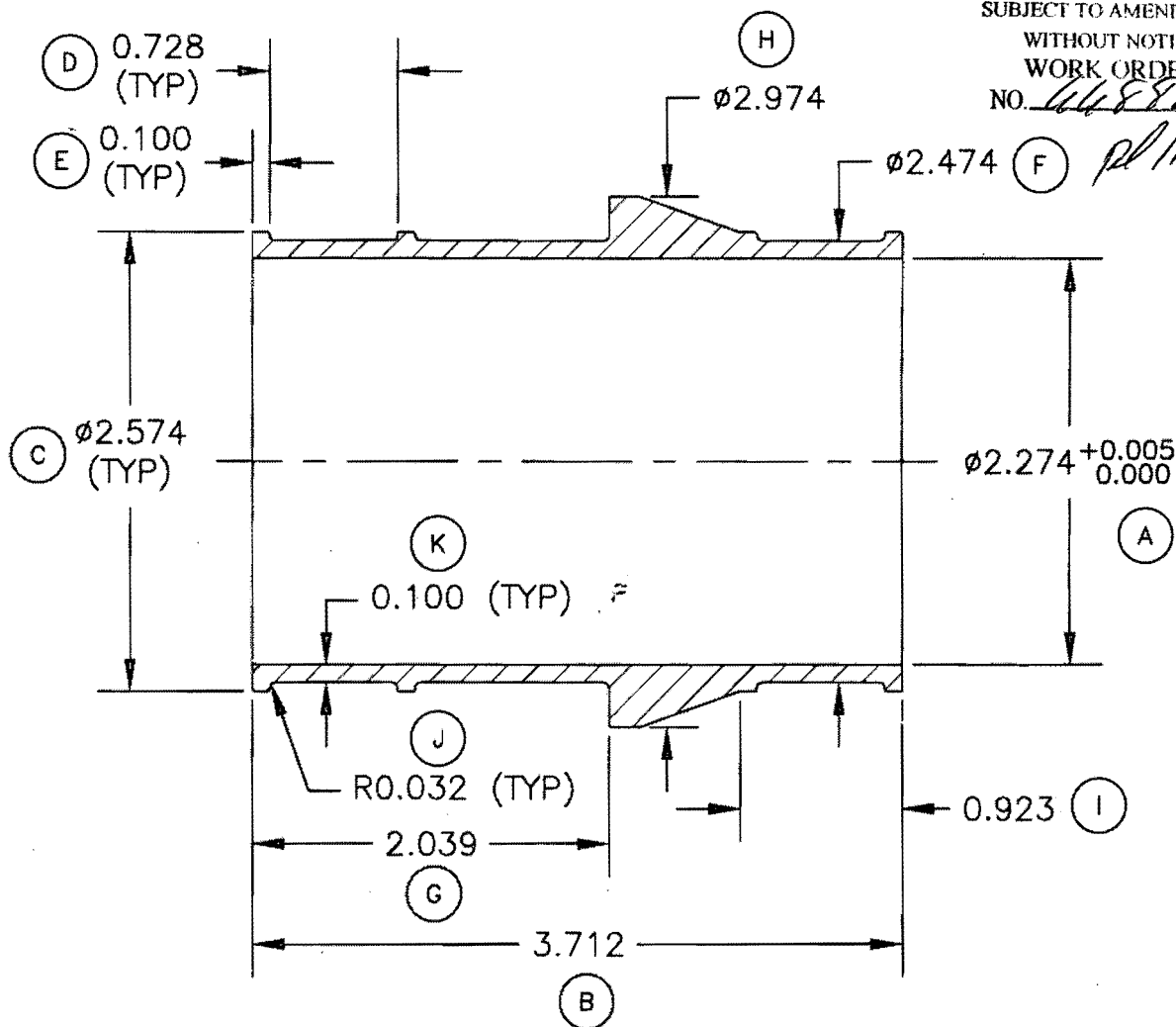
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
[Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44882
[Signature]



D2891-1 TURNING DETAIL

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